

Date: Thursday, 2/22/2007 2:49:30 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|---|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : OH-58 STEP ASSY LH *UNDER REVIEW** |
| Job Number | : 30793 | | |
| Estimate Number | : 12438 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D058677011 |
| This Issue | : 2/22/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D2943 UNDER REVIEW |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LARGE FAB ASSY | Drawing Revision | : UNDER R Rev B <i>PH 07.02.23</i> |
| Previous Run | : 28722 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 3/10/2007 Qty: 3 Um: Each |
| Checked & Approved By | : <i>[Signature] 07.02.23</i> | | |
| Comment | : Est Rev.B 01.04.11 Combined with D2943-041 EC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|------------------------------|
| 1.0 | DC | DOCUMENT CONTROL |
| 2.0 | D2622120C | Extrusion |
| 3.0 | D2734 | 206 Step Endplate |
| 4.0 | D2725 | 206 Step Lug |
| 5.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |



Comment: Photocopy bluefile & type labels per PPPD058-677-011

CHG 001

KS 07.03.01

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Extrusion D2622-120C

Batch: *329607**KE. 07.03.03*

* Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

D2734 206 Step Endplate

Batch: *327281**KE. 07.03.03*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

D2725 206 Step Lug

Batch: *330882**KE. 07.03.03*

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

A/R AL RQD

Batch: *M100237 M102225**KE. 07.03.03**KE. 07.03.05**KE. 07.03.05*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 30793

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind end cap welds flush as per dwg D2943

P.E. 07-03-08 3

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/09 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/09 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.J. / M.H. 07-03-19 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P.E. 07-03-20 3

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: *M100237**P.E. 07-03-20 3*

2-Grind end cap welds flush as per dwg D2943

FF 07-03-20 3

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/20 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/20 (3)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

A.M. 07/03/21 (3)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 30793

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M.

07/03/21

(3)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: *M103480*

M.L.

07/03/21

(3X)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P.U. 7/3/22

(3)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

P.U.

07/03/23

(3)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

P.U.

07/03/23

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: *B9441 2X*
B8302 2X

B20613 2X

20.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

B27420

21.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: *B22591 3X*

B23330 3X

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 30793

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Mounting Lug

Batch: B28936

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: M100743

24.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Batch: M6071 - 8X - M102380 1X - M102928 1X - M102029 13X

25.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Batch: M103338

26.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut

Batch: M103349

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location:

PPP Rev: B

P-7/3/22 (2)
P-7/3/23 (3) 50

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/26

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 30793

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC21

FINAL INSPECTION/W/O RELEASE



③

Comment: FINAL INSPECTION/W/O RELEASE

2/20/03/06

Job Completion



U 04-03-26

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

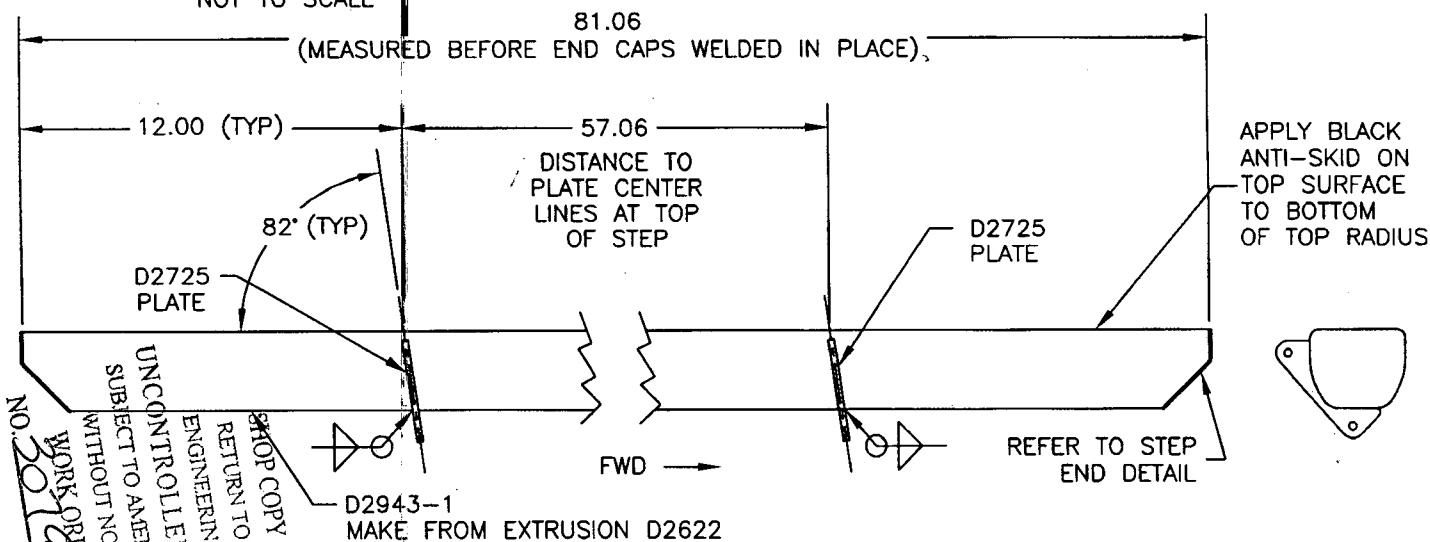
DART

| DESIGN | RF | DRAWN BY | DART AEROSPACE USA, INC. | REV. B |
|---------|--------------------|----------|---------------------------|--------------|
| CHECKED | <i>[Signature]</i> | APPROVED | DRAWING NO. D2943 | SHEET 1 OF 1 |
| DATE | 05.11.14 | | TITLE OH-58 STEP ASSEMBLY | SCALE NTS |
| A | 99.11.19 | | NEW ISSUE | |
| B | 05.11.14 | | UPDATE FINISHING NOTE | |

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE



D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|----------|----------|-------------|------------------|
| X | | D2943-041 | LH STEP ASSEMBLY |
| | X | D2943-042 | RH STEP ASSEMBLY |
| 1 | 1 | D2622-082* | EXTRUSION |
| 2 | 2 | D2725 | PLATE |
| 2 | 2 | D2734 | END PLATE |

*out per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28-14

UNDER REVIEW
06.02.29
RE-DESIGN
SIMILAR TO 0206-508
07.02.23